May-30-13 1:50:17 PM

Revision ID:	D3957-4			Accept	*N900	1040	100)* s	etup Stai	^t *N	S1*
	Hinge. Door R	RH Lower							Sto	*N	S2*
Start Date: Required Date: Reference:	5/30/13 6/06/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:	ID:					
Approvals:		n: ML5	Date:/3-05-3d	Tooling: _ SPC (Y/N):		ate:		R ·	tun Stai Sto	1/1	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3957	Α										
*100 *100* Bandsaw Jeaspa Bandsaw		Memo cut blank to	3.200" long	0.00	M 13/06/	05		1	_6_		
110 HAAS I HAAS CNC vertical	machine #1	FOLIO REV DWG REV:		0.00		6/04					(AS)

3-DEBURR AS PER dWG

DQA:			. Date:											DADT.
						WORK ORDER NON-	-C(ONFO	RMANCE / U	PDATE				DAR I AEROSPACE
QA Closed:			Date:					_			W	ork Order up	odate only	
Work Ord	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
	_		_		_	Rework]		Skid-tube	Crosstube]	Water Jet	Engineering
Part !	No.					Scrap		l	Machining	Small Fab		Pro	d. Eng. Coor.	Quality
						Use-as-is		Therr	noforming	Finishing		Rec/Stor	re/Packaging	Other
NCR I	No	<u>.</u>			_	Suspected Unapproved			Large Fab	Composite			Supplier	
Root		·			Desci	ription of work order update		Initial	Act	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription		Date	Verification	QC Inspector
Design	Ш					,								
Doc/Data	Ц												ī	·
Equip/Tooling	Ц												•	
Handling/Pre	Н													
Material	Н													
Operator	Н													
Offset/Setup	Н													
Process Supplier	Н													
Training	Н													
Transport	H											٠.		
Unapproved	Н		<u> </u>											
			1	11			FAI	ULT CA	TEGORY					
Landi	ng G	ear				General								
		Bending				Bend		Folio/F	'rogram			Outside Dim	ensions [Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		•		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorrec	rt 📙	Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified		Part Lost/Mi	ssing	Weld
	Ш	Cuffs				Contamination		Instruct	ions Incomplete/U	Inclear		Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center			Positioned W	/rong	
		Heat Trea				Cut Too Short		Mislabe	led			Power Loss/S	Surge	Other
	-	nspection	٠.	Tube		Drawing	L	Misread	i					
	\vdash	Marks/Ch				Drill Holes	L	Off-set						
	-	Turning Se			-	Finish		4	Calibration					
	\	Nave/Tw	ist in Tub	e		Fit/Function	i i	Out of 9	Sequence					1

May-30-13 1:50:17 PM

Item ID: **Revision ID:**

3,

D3957-4

Accept

N900040100

Setup Start

Item Name:

Start Date:

Required Date: 6/06/13

Hinge. Door RH Lower

5/30/13

Start Qty: 1.00 Req'd Qty: 1.00 *1* *1*

Cust Item ID:

Customer:

Approvals:	Process I	Plan:	Date:	Tooling: SPC (Y/N):		Da Da				tun Stai	171	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120* QC Quality Control		QC2- Inspect parts of Memo	f machine FAI/FAIB	0.00	۵.۵	13/00	, 106			4	****	0A 08 28
30 *130* QC Quality Control		QC8- Inspect parts - s	econd check	0.00	J)	13-04-0	Œ			æ		

140

140 HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00 Memo

1 16 13.6.7

DQA:		_ Date:												TAAC
					WORK ORDER NON	-C(ONFO	RMANCE / U				_		AEROSPACE
QA Closed:		Date:					7			Work C	rder u	odate only		
Work Orde	r:				DISPOSITION				AGAINST	DEPAR	TMENT	/PROCESS		
	·· 				Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	0.				Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	┨`	Quality
					Use-as-is	1	i	noforming	Finishing	\dashv $_{F}$		re/Packaging	\dashv	Other
NCR N	o				Suspected Unapproved			Large Fab	Composite			Supplier		
D 4		T	r	Dane	:ki		 				0	<u> </u>		
Root	Data	Ston	0+4	Desci	ription of work order update		Initial	1	tion	ı	gn &	Vanification		OC Incorporate
Cause	Date	Step	Qty		or non-conformance	Cn	nief Eng	Descr	ription		Date	Verification		QC Inspector
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Landin	g Gear				General	_	,		-			_		
	Bending				Bend	_	1	Program		Outs	ide Dim	ensions	— 1	essure/Forced
		lot Conce	ntric		BOM/Route		Grain			Ove	r/Under	tolerance	_	t-up
	Cracks			-	Broken/Damage/Defect	L.	Hardwa				Incorre	-	_	mperature/Cure
		ink/Ripple	/Wave	<u> </u>	Burrs	<u> </u>	1 .	ion Incomplete/Ur	· · · · · · · · · · · · · · · · · · ·		Lost/Mi	ssing	_	eld
	Cuffs			<u> </u>	Contamination	_	4	ions Incomplete/l	Jnclear		Moved	L	Wr	ong Stock Pulled
-	Crushing			<u> </u>	Countersink	<u>_</u>	1	ned/off center		—	tioned V			
-	Heat Tre			<u> </u>	Cut Too Short		Mislabe		Į	Pow	er Loss/	Surge [Ot	her
-		on Strip in	Tube		Drawing	<u> </u>	Misread							
}	Marks/C			<u> </u>	Drill Holes	<u> </u>	Off-set							
-		Sequence		<u> </u>	Finish	<u> </u>	4	Calibration						
	TWave/Tr	wist in Tub	e e	ı	Fit/Function	I	IOut of 9	Sequence						

Page 3

May-30-13 1:50:17 PM Item ID: D3957-4 Accept *N900040100* Setup Start **Revision ID:** Item Name: Hinge. Door RH Lower *1* **Start Date:** 5/30/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/06/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date: Stop Date: QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ **Tool ID** Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Stamp Qty Number 150 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum *150* Powdercoat Memo Powder Coating MASK THREADED HOLE m 26620 160 QC3- Inspect Part Finish 0.00 *160* 0.00 Memo Quality Control Identify as per dwg & Stock Location: 4. A 170 0.00 *170* Packaging 0.00 Memo Packaging

DQA:		Date:											•	™ ∆APT
QA Closed:		Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U	IPDATE	W	ork Order uj	odate only		AEROSPACE
					DISPOSITION				AGAINST		PARTMENT		<u> </u>	1
Work Orde	r:					,					-			. —
Part N					Rework			Skid-tube	Crosstube	⊢		Water Jet	<u> </u>	Engineering
raitiv	U				Scrap			Machining	Small Fab	⊢	4	d. Eng. Coor.		Quality
NCR N	О.				Use-as-is Suspected Unapproved		merr	noforming Large Fab	Finishing Composite		Rec/Sto	re/Packaging Supplier	$\overline{}$	Other
· · · · · · · · · · · · · · · · · · ·		,	1			لـــا							•	
Root				Desci	ription of work order update	1	Initial		tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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Handling/Pre														
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	Bending				Bend		Folio/F	rogram			Outside Dim	ensions		Pressure/Forced
	Centre N	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
Γ	Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	ct		Temperature/Cure
Ī	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	ssing		Weld
	Ċuffs				Contamination		Instruct	ions Incomplete/	Unclear		Part Moved			Wrong Stock Pulled
	Crushing				Countersink	$\overline{}$	1	ned/off center			Positioned V			-
ľ	Heat Trea				Cut Too Short	$\overline{}$	Mislabe				Power Loss/	-		Other
ľ	Inspectio	n Strip in	Tube		Drawing	\vdash	Misrea			_	•	-		
	Marks/Cl	٠.			Drill Holes	\vdash	Off-set							
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1	Wave/Tw	-			Fit/Function	\vdash	1	Sequence				·		

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May-30-13 1:50:17 PM

Item ID: D3957-4 Accept *N900040100* Setup Start **Revision ID:** Item Name: Hinge. Door RH Lower **Start Date:** 5/30/13 Start Qty: 1.00 **Cust Item ID:** Required Date: 6/06/13 Req'd Qty: 1.00 **Customer:** Reference: Run Process Plan: Approvals: Date: Tooling: Date: Stop Date:_____ **SPC (Y/N):** Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. **Work Center ID** Description Number Stamp **Run Hours** Code Qty Qty 180 QC21- Final Inspection - Work Order Release 0.00 *180* QC 0.00 Memo Quality Control

13-6-9

DQA:		Date:											4	[™] ⊃∧DT
					WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:		Date:								W	ork Order u	odate only		
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	· ·	-			Rework	1		Skid-tube	Crosstube		ן	Water Jet		Engineering
Part N	0.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
					Use-as-is			noforming	Finishing		-	re/Packaging		Other
NCR N	0				Suspected Unapproved			Large Fab	Composite			Supplier	\vdash	
Root				Desci	ription of work order update		Initial	Ac	tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Design														
Doc/Data														
Equip/Tooling		ŀ												
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Material														
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·	Bending				Bend		1	rogram			Outside Dim		-	Pressure/Forced
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	Cracks				Broken/Damage/Defect		Hardwa				Part Incorred			Temperature/Cure
-	Crimp/Kir	nk/Ripple	/Wave	-	Burrs		1 '	on Incomplete/U	•		Part Lost/Mi	-	Н	Weld
-	Cuffs			-	Contamination		1	ions Incomplete/I	Unclear	_	Part Moved			Wrong Stock Pulled
	Crushing			-	Countersink		٠ -	ned/off center		_	Positioned V	_		
-	Heat Trea			-	Cut Too Short	<u> </u>	Mislabe			L	Power Loss/	Surge	Ш	Other
	Inspection		Tube	<u> </u>	Drawing	<u> </u>	Misread	I	•		•			
1	Marks/Ch			<u> </u>	Drill Holes		Off-set							
	Turning S			<u> </u>	Finish		1	Calibration						
	Wave/Tw	ist in Tub	oe		Fit/Function		Out of S	equence	, s					

Picklist Print

May-30-13 1:50:21 PM

Work Order ID: 102551

102551

Parent Item:

D3957-4

D3957-4

Parent Item Name: Hinge. Door RH Lower

Start Date: 5/30/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
M6061T6B0.750X03.00		Purchased	No			100	f.	16.1460	0.266	0.28				_

M6061T6B0 750X03 000

Location	Loc Qty	Loc Code
MAT049	16.146	
\(\) 104741	4.146	
125272	12	

**

128 orl 13/06/05

DQA:		_ Date:											4	™ ⊃∧DT
		_			WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:		Date:					·	· -		W	ork Order u	odate only		
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
					Rework	1		Skid-tube	Crosstube	Г	1	Water.Jet		Engineering
Part N	0.				Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	-	Quality
	•				Use-as-is		Therr	moforming	Finishing		4	re/Packaging	_	Other
NCR N	0				Suspected Unapproved]		Large Fab	Composite]	Supplier	,	
Root				Desci	ription of work order update		Initial	Act	tion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Desci	ription		Date	Verification	n	QC Inspector
Design									•					
Doc/Data														
Equip/Tooling					•									
Handling/Pre														
Material														
Operator														
Offset/Setup					:									
Process														
Supplier														
Training		1	· .		•									
Transport														
Jnapproved					·									•
						FAI	ULT CA	TEGORY						
Landin	g Gear				General		_							
	Bending				Bend		Folio/F	Program			Outside Dim	ensions		Pressure/Forced
L	Centre N	ot Conce	ntric		BOM/Route		Grain				Over/Under	tolerance		Set-up
L	Cracks				Broken/Damage/Defect		Hardwa	are			Part Incorre	ct [Temperature/Cure
L	Crimp/Ki	nk/Ripple	/Wave		Burrs .		Inspect	ion Incomplete/Ur	nqualified		Part Lost/Mi	ssing		Weld
L	Cuffs				Contamination		Instruct	tions Incomplete/l	Jnclear		Part Moved	[Wrong Stock Pulled
	Crushing				Countersink		Misalig	gned/off center			Positioned V	-		
	Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge		Other
	Inspectio	n Strip in	Tube		Drawing		Misread	d						
	Marks/Cl	natter			Drill Holes		Off-set							
	Turning S	equence			Finish		Out of	Calibration						
	Wave/Tw	vist in Tul	oe		Fit/Function		Out of	Sequence						

DART AEROSPACE LTD	Work Order:	105221
Description: Hinge, Door RH Lower	Part Number:	D3957-4
Inspection Dwg: D3957 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	+/-0.030	0.686	~		Vern	GA-01
0.281	+/-0.010	0.281	1		11	11
0.281	+/-0.010	0.281	✓		1	н
3.00	+/-0.030	2.997	~		//	
R0.13	+/-0.030	RO.125	~		R-6	ref.
0.563	+/-0.010	0.562	✓		Vern	6A-01
1.25	+/-0.030	1.252	1		11	11
1.93	+/-0.030	1.936	~		1)	11
107°	+/-0.5°	107°	>		Anale M.	CUC-03
0.250	+/-0.010	0.251	\		Angle M. Vern	6A-01
Ø0.203 —	+0.005/-0.001-					
-1:170	+/-0.010					-
_0.30	. -+/-0.030					
_0.33	-+/-0.030					
Ø0.063	+0.004/-0.001	\$0.067	✓ ·		Vein	6A-01
0.125	+/-0.010	0.122	~		1,	11
0.094	+/-0.010	0.090	~		11	//
0.12	+/-0.030	0.150	·		11	11
R0.50	+/-0.030	Ro500	~	,	R-6	· ref.

Measured by:	D.0 10AC	Audited by:	11	Prototype Approval:	N/A
Date:	13/06/06 0-89	Date:	13-06-06	Date:	N/A

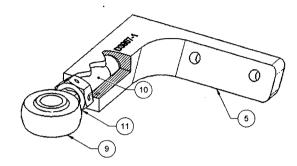
Rev	Date	Change	Revised by,	Approved
A	09.12.14	New Issue	. KJ 94	M

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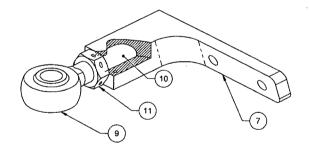
DQA:			Date:				_						*	ືລΔRT
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UPDAT		ork Order up	odate only		AEROSPACE
Work Orde	r:					DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No						Rework Scrap Use-as-is Suspected Unapproved	crap Machining Small Fa as-is Thermoforming Finishir			all Fab	b Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
Root					Desc	ription of work order update		nitial	Action	•	Sign &			
Cause		Date	Step	Qty		or non-conformance	Cr	ief Eng	Description		Date	Verification	1	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							FA		TEGORY					
Landin	na G	inar .				· · · · · · · · · · · · · · · · · · ·	FA	ULI CA	IEGURY					
Landir		Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning So	nk/Ripple, et n Strip in eatter	/Wave		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspecti Instruct Misalig Mislabe Misread Off-set	ion Incomplete/Unqualifie ions Incomplete/Unclear gned/off center eled		Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong		Pressure/Forced Set-up Femperature/Cure Weld Wrong Stock Pulled Other
1	Wave/Twist in Tube					Fit/Function		Out of 9	Sequence					

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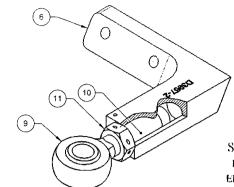
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION		
1	Х				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER		
2		×	:		D3957-042	HINGE ASSEMBLY, DOOR RH UPPER		
3			×		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER		
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER		
5	1			İ	D3957-1	HINGE, DOOR LH UPPER		
6		1			D3957-2	HINGE, DOOR RH UPPER		
7			1		D3957-3	HINGE, DOOR LH LOWER		
8				1	D3957-4	HINGE, DOOR RH LOWER		
9	1	1	1	1 D3518-3		ROD END		
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF		
11	1	1	1	1	NAS509-6	NUT		



D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



SHOP COLLÉ RETUR' TO ENGINET RING

UNCONTROLLED COPY

SUBJECT TO AT 15 NOME ST

D3957-042 HINGE ASSY, DOOR RH UPPER

WITHOUT : ... ICE

WORK OR - R NO_1025TI MW

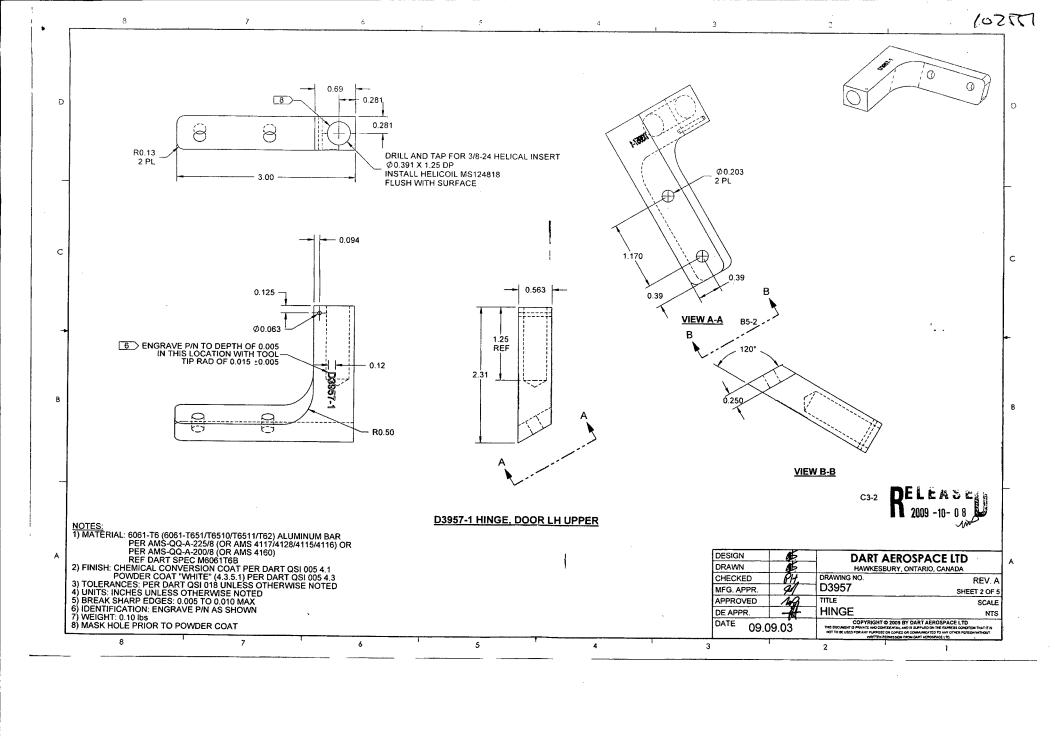
13-05-30



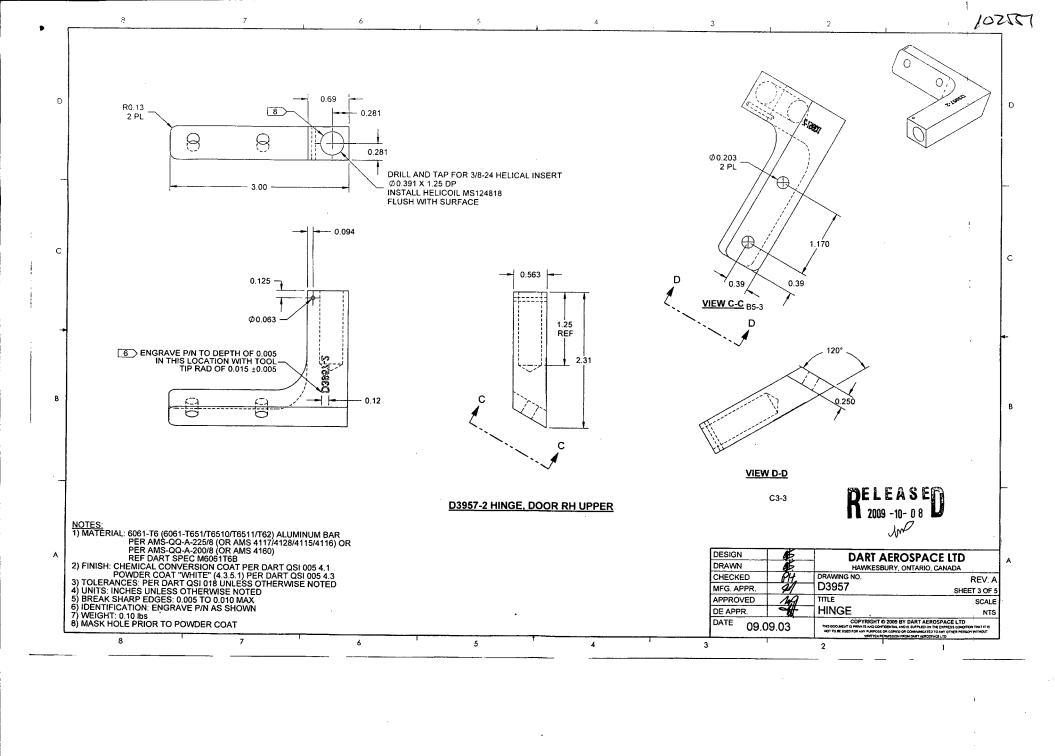


Α	NEW IS	SUE		45	09.09.03					
REV.			DESCRIPTION	BY	DATE					
DESIG		4 5	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA							
CHECK MFG. A		PH,	DRAWING NO.		REV. A					
APPRO DE API		19	TITLE HINGE		SCALE NTS					
DATE	09.0	9.03	THIS DOCUMENT IS PREVATE AND CONFIDENT NOT TO BE USED FOR ANY PURPOSE OR CO		COMOTION THAT IT IS					

DQA:			Date:												
						WORK ORDER NON	WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:				Work Order update only								
Work Orde	er:				į	DISPOSITION				AGAINST	DE	DEPARTMENT/PROCESS			
Part I	- No					Rework Scrap Use-as-is		Machining Small Fab		Crosstube Small Fab Finishing	Prod. Eng. Coor.		d. Eng. Coor.	Engineering Quality Other	
NCR I	No					Suspected Unapproved L			Large Fab	Composite]	Supplier		
Root					Desci	ription of work order update		nitial	Acti	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC Inspector	
Design															
Doc/Data												! !			
Equip/Tooling	\Box														
Handling/Pre					:										
Material	\dashv											:			
Operator						•									
Offset/Setup	\dashv														
Process Supplier															
Training															
Transport	\dashv														
Unapproved	\vdash											<u> </u>			
			I		<u> </u>		FAI	ULT CAT	TEGORY			<u> </u>		<u> </u>	
Landi	ng G	iear				General									
'		Bending				Bend		Folio/P	rogram			Outside Dim	ensions [Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain	0			Over/Under	⊢	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire			Part Incorred	_	Temperature/Cure	
		Crimp/Kin	k/Ripple,	/Wave		Burrs		Inspecti	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld	
	Crimp/Kink/Ripple/Wave Cuffs					Contamination		1	ions Incomplete/U			Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misalig	ned/off center			Positioned V	/rong	_	
•	Heat Treat					Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misread	1						
į	Marks/Chatter Drill Holes					Drill Holes		Off-set	***			-			
* ¹	Turning Sequence Finish					Finish		Out of (Calibration						
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence						

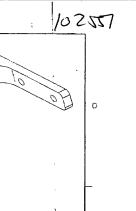


DQA:		Date:												
OA Classide		Doto			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									
QA Closed:		Date:					<u> </u>		W	ork Order up	date only			
Work Orde	er:				DISPOSITION AGAINST				AGAINST DI	T DEPARTMENT/PROCESS				
				_	Rework	1	Skid-tube Crosstube			7	Water Jet	Engineering		
Part N	No.				Scrap		<u>.</u>	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	· 1			Finishing	Rec/Stor	re/Packaging	Other		
NCR 1	No							Composite]	Supplier				
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Root				Desci	ription of work order update	ł	Initial	Actio		Sign &	_			
Cause	Date	Date Step Qty			or non-conformance	Cr	nief Eng	Descrip	otion	Date	Verification	QC Inspector		
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	Bendin	g			Bend		Folio/F	rogram	·	Outside Dim	ensions	Pressure/Forced		
	Centre	Not Conce	ntric		BOM/Route		Grain		ļ	Over/Under	tolerance	Set-up		
	Cracks				Broken/Damage/Defect	L	Hardwa	re		Part Incorred	ct	Temperature/Cure		
·	⊢ ⊣ '	Kink/Ripple	e/Wave		Burrs	L	Inspect	ion Incomplete/Unq	qualified	Part Lost/Mi	ssing	Weld		
	Cuffs				Contamination	<u> </u>	4	ions Incomplete/Ur	nclear	Part Moved		Wrong Stock Pulled		
,m-	Crushir	-		_	Countersink	L	-1	ned/off center		Positioned V	_]]		
ينه و ا	Heat Ti			<u> </u>	Cut Too Short	<u></u>	Mislabe			Power Loss/	Surge	Other		
		ion Strip in	1 Tube	<u> </u>	Drawing	L	Misread	1						
		Chatter		_	Drill Holes	<u></u>	Off-set							
		Sequence		-	Finish	<u> </u>	4	Calibration						
	i iwave/	Twist in Tul	ne		Fit/Function	1	1Out of 9	Sequence						

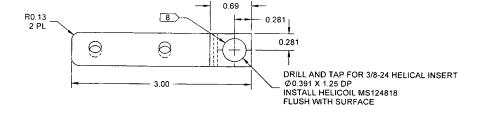


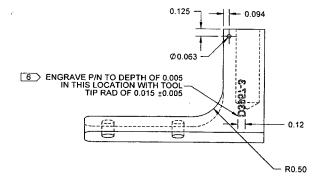
DQA: _		_ Date:										™ ∆APT	
QA Closed:		Date:			WORK ORDER NON-	-C(ONFO	RMANCE / UPDATE	W	ork Order u	odate only	AEROSPACE	
Work Orde	r:			-	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No					Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite		b g	Prod. Eng. Coor Rec/Store/Packaging		Engineering Quality Other		
Root		T	<u> </u>	Dosc	ription of work order update		Initial	Action		Cian 0		<u> </u>	
Cause	Date	Step	Qty	Desci	or non-conformance		initial lief Eng	Description		Sign & Date	Verification	QC Inspector	
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Landin	g Gear				General				-		·····		
Γ	Bending				Bend		Folio/P	rogram	Г	Outside Dim	ensions	Pressure/Forced	
	Centre N	ot Concei	ntric		BOM/Route		Grain			Over/Under	├	Set-up	
	Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorred	⊢	Temperature/Cure	
	Crimp/Ki	nk/Ripple	/Wave		Burrs		l	on Incomplete/Unqualified	\vdash	Part Lost/Mi		Weld	
Ì	Cuffs				Contamination		1	ions Incomplete/Unclear	\vdash	Part Moved		Wrong Stock Pulled	
	Crushing				Countersink		l	ned/off center	\vdash	Positioned V	∟ Vrong		
<u> </u>	Heat.Trea				Cut Too Short	_	Mislabe		\vdash	Power Loss/		Other	
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	Marks/Cl				Drill Holes		Off-set						
T	Turning S				Finish		ł	Calibration					
	Wave/Tw				Fit/Function		•	Sequence					

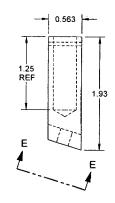
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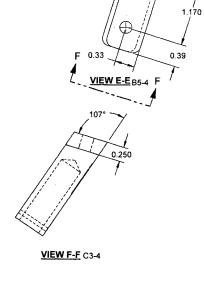


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RELEASED

D3957-3 HINGE, DOOR LH LOWER

NOTES:
1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-225/8 (OR AMS 411//4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION:ENGRAVE P/N AS SHOWN 7) WEIGHT: 0.09 IDS 8) MASK HOLE PRIOR TO POWDER COAT

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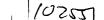
DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED REV. A D3957 MFG. APPR. SHEET 4 OF 5 APPROVED TITLE SCALE HINGE DE APPR. NTS COPYRIGHT © 2009 BY DART AERO SPACE LTD
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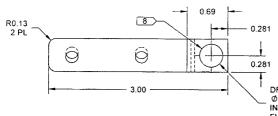
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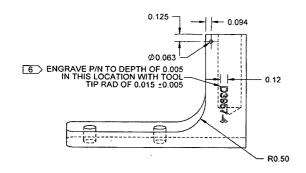
DQA:		Da	ate: _				DART							
QA Closed:		Da	ate:			WORK ORDER NON	-C(ONFO	RMANCE / U	IPDATE	W	ork Order up	odate only	AEROSPACE
Morle Orde		-	•			DISPOSITION				AGAINST		PARTMENT		·
Work Orde						Rework Scrap		Skid-tube Crosstube Machining Small Fab			_	Pro	Water Jet	Engineering Quality
NCR N	No				_	Use-as-is Suspected Unapproved	Thermoforming Finishing Large Fab Composite				-{	re/Packaging Supplier	Other	
Root					Descr	iption of work order update		nitial	Ac	tion		Sign &		
Cause	Dat	e St	ер	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	QC Inspector
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Lanuii	n g Gear Bendi	~~				General Bend]/n	rogram			Outside Dim		ا ا
		ig Not Co	nconti	ric	-	BOM/Route	<u> </u>	Grain	rogram		-	-{	⊢	Pressure/Forced
	Cracks		псени	110		Broken/Damage/Defect	\vdash	Hardwa			-	Over/Under Part Incorred	<u> </u>	Set-up
) /Kink/Ri _l	nnlo /\	Mayo		Burrs	⊢	l	re on incomplete/U	ngualified	-	4	├	Temperature/Cure
	Cuffs	/ KILIK/ KI	hhie) v	vvave	-	Contamination	\vdash		ions Incomplete/U	•	⊢	Part Lost/Mi Part Moved	221118	Weld
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	_	ction Stri	n in Tı	uhe	-	Drawing	\vdash	Misreac			L	Ti OMEL FOSSY	Dui Re	Totilei
		/Chatter	٠.		\mathbb{H}	Drill Holes	Off-set							
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İ	Turning Sequence					Fit/Function	\vdash	•	Calloration					

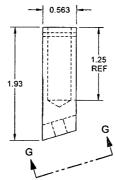


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DRILL AND TAP FOR 3/8-24 HELICAL INSERT Ø0.391 X 1.25 DP **INSTALL HELICOIL MS124818** FLUSH WITH SURFACE

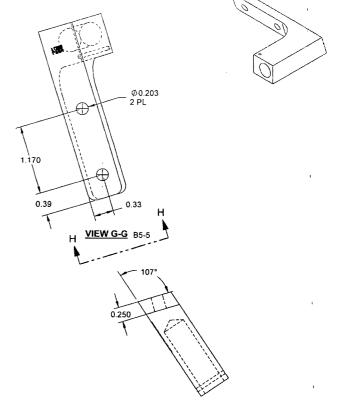




D3957-4 HINGE, DOOR RH LOWER

NOTES:
1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-220/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ENGRAVE P/N AS.SHOWN 7) WEIGHT: 0.09 ibs 8) MASK HOLE PRIOR TO POWDER COAT

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VIEW H-H C3-5

DESIGN	15	DART AEROSPACE LTD							
DRAWN	45	HAWKESBURY, O	NTARIO, CANADA						
CHECKED	PH.	DRAWING NO.	REV. A						
MFG. APPR.	94	D3957	SHEET 5 OF 5						
APPROVED	143	TITLE	SCALE						
DE APPR.	-#	HINGE	, NTS						
DATE 09.0	9.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT OF PRIVATE AND CONFEDERMUL AND IS SUPPLED ON THE EMPRESS CONCITION PAINT IS NOT THE BUSINESS OF COMMENTS OF COMMENCE AT DOTAL AND OTHER PRESSON WITHOUT WAY THE PRIVATE AND LOST AND LO							

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DQA:	Date:												
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QA Closed:			Date:							V	Vork Order u	pdate only	
Work Ord	er:					DISPOSITION		:		AGAINST D	EPARTMENT	/PROCESS	
ı	-					Rework	1	Skid-tube Crosstube			7	Water Jet	Engineering
Part I	No.				<u> </u>	Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
NCR I	No.					Use-as-is Suspected Unapproved	Thermoforming Finishing Large Fab Composite			Rec/Sto	re/Packaging Supplier	Other	
Root					Desc	ription of work order update	П	nitial	Act	ion	Sign &		á, k,
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	Ш	Bending	•			Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
	Ш	Centre No	ot Concer	ntric		BOM/Route		Grain		L	Over/Under	tolerance	Set-up
	Ш	Cracks				Broken/Damage/Defect		Hardwa	are	L	Part Incorre	ct	Temperature/Cure
÷	Ш	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	issing	Weld
• • •		Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misalig	gned/off center	·	Positioned V	Vrong	
	Heat Treat					Cut Too Short		Mislabe	eled	Γ	Power Loss/	Surge	Other
	\square	Inspection	n Strip in	Tube		Drawing		Misread	d				
	Ш	Marks/Ch	atter			Drill Holes		Off-set					
A		Turning S	equence			Finish		Out of (Calibration			•	
A A A A	Wave/Twist in Tube					Fit/Function		Out of	Sequence				

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